

Date: Thursday, 12/21/2006 12:01:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
 Job Number : 30062
 Estimate Number : 10305
 P.O. Number : *UHA*
 This Issue : 12/21/2006 S.O. No. : *UHA*
 Prsht Rev. : NC
 First Issue : *UHA* Type : PURCHASED PARTS
 Previous Run : 23779
 Written By :
 Checked & Approved By : *OK 12 21*
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM

Part Number : D2423
 Drawing Number : D2423 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material : *UHA*
 Due Date : 1/2/2007

Qty: *405* (360) Um: Each

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|----------------------------------------------------------------------------------------------------------------|-----------------------------------|-------------------------------------------------------|
| 1.0 | PG | PURCHASING |
| 2.0 | D2423P | Lug Extrusion |
| Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s) <i>→ 405'</i> Lug Extrusion <i>106112122 (360 FT)</i> | | |
| 3.0 | PACKAGING 1 <i>ENSURE Q&A</i> | PACKAGING RESOURCE #1 <i>7/1/11 (45 mcp) 405 SPIM</i> |
| 4.0 | QC6 | DIMENSIONAL CHECK <i>07.01.17 (45) 405</i> |
| 5.0 | PACKAGING 1 <i>CNC</i> | PACKAGING RESOURCE #1 <i>07.01.17 405</i> |
| 6.0 | QC21 | FINAL INSPECTION/W/O RELEASE <i>(405)</i> |
| Comment: FINAL INSPECTION/W/O RELEASE <i>07/07/18</i> | | |
| Job Completion <i>U 07-01-18</i> | | |



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

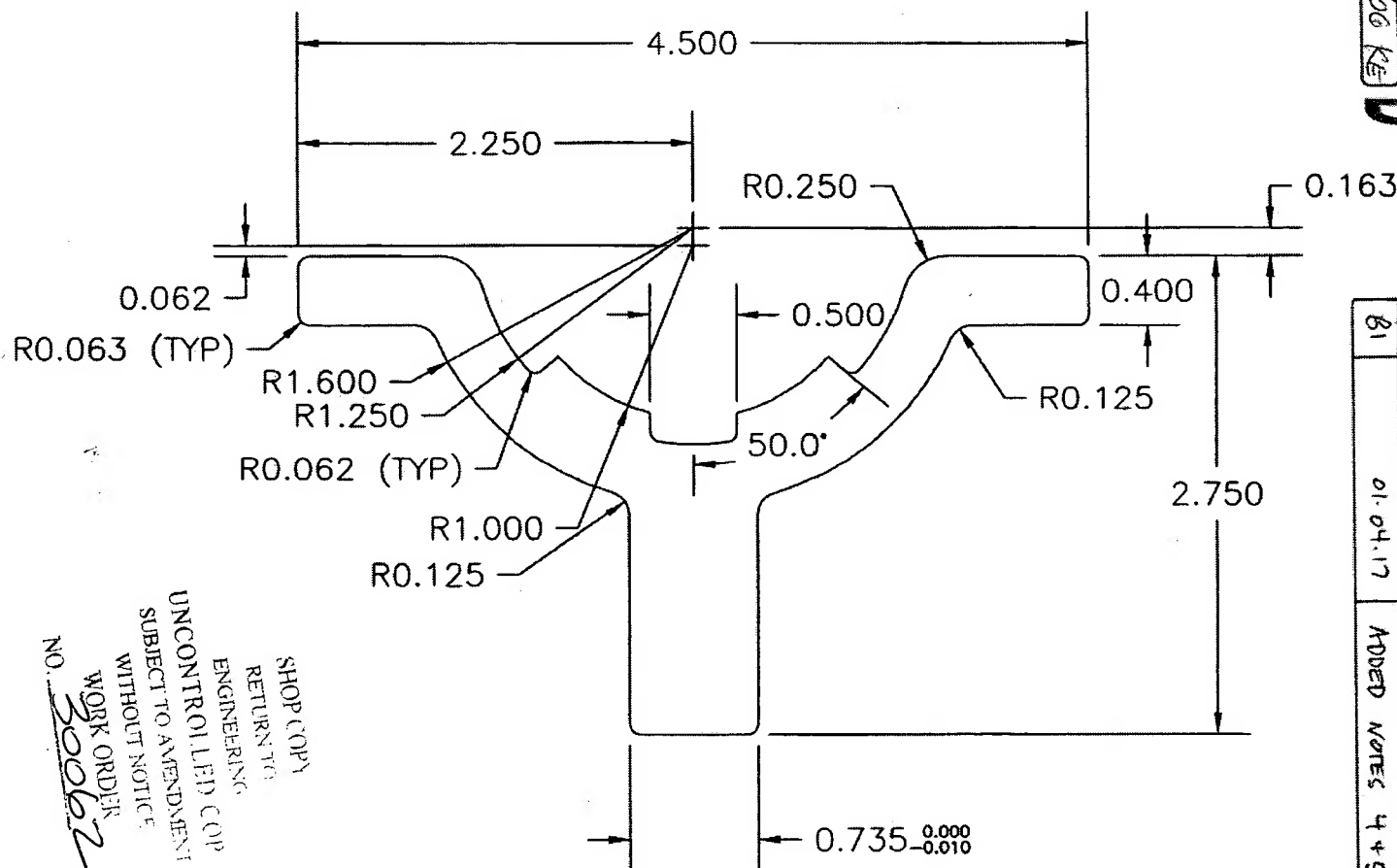
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 07/01/18
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART**RELEASED**
98/08/06 KE

| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
|----------|----------|-----------------------------|--------------|
| LE | KE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 1 |
| 98/08/04 | 98/08/04 | D2423 | |
| DATE | TITLE | LUG EXTRUSION | SCALE |
| 98.08.04 | | | 1:1 |
| A | 95.05.09 | NEW ISSUE | |
| B | 98.08.04 | 6061-T6 WAS 6005A.T5 | |
| B1 | 01.04.17 | ADDED NOTES 4+5 | |



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDIALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)



INDALEX LIMITED
 325 AVRO Street
 POINTS-CLAIRE, QC H9R 5W3
 TELEPHONE: (514) 697-5120 & (800) 563-5120
 FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young

FROM: Bruno Morency
Quality Technician

COMPANY:

DART AEROSPACE LTD

DATE:

2007/01/11

FAX NUMBER:

1(613) 632-4443

TOTAL NO. OF PAGES INCLUDING COVER:

2

PHONE NUMBER:

SENDER'S REFERENCE NUMBER:

SUBJECT:

REPORT

TIME:

☐ URGENT ☐ FOR REVIEW ☐ PLEASE COMMENT ☐ PLEASE REPLY ☐ PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report.

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325 rue Avro
Pointe-Clair QC H9R 5W5

Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 6122430

bon de commande / Purchase order # : 2770

de matrice / Die # : MS 18868 Description: LUG EXTRUSION

Alliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 36341-1

Coulée / Cast # : 36731

| | Min.requis Min. required | Résultat actuel Actual results |
|--------------------------------------------|-----------------------------|-----------------------------------|
| Tension ultime Ultimate stress (psi) | 58 000 | 49280 |
| Contrainte élastique Yield stress (psi) | 35 000 | 36676 |
| % élongation dans 2" | 8 | 12.5 |
| Dureté Rockwell E (Hr) | 88 @ 100 | 88 |

Composition chimique typique / Typical chemical composition :

| | Al | Fe | Cu | Mn | Mg | Cr | Zn | Ti |
|-------|-------------|-------------|-------------|-------------|-------------|-------------|----------|----------|
| 6063 | 0.20 - 0.60 | 0.35 Max | 0.10 Max | 0.10 Max | 0.45 - 0.90 | 0.10 Max | 0.10 Max | 0.10 Max |
| 6005 | 0.40 - 0.90 | 0.35 Max | 0.10 Max | 0.10 Max | 0.40 - 0.60 | 0.10 Max | 0.10 Max | 0.10 Max |
| 6005A | 0.48 - 0.72 | 0.15 - 0.27 | 0.08 - 0.12 | 0.20 - 0.24 | 0.48 - 0.82 | 0.03 Max | 0.05 Max | 0.03 Max |
| 6061 | 0.40 - 0.80 | 0.70 Max | 0.15 - 0.40 | 0.15 Max | 0.80 - 1.20 | 0.04 - 0.35 | 0.25 Max | 0.15 Max |
| 6061 | 0.7 - 1.3 | 0.6 Max | 0.10 Max | 0.40 - 0.80 | 0.40 - 0.80 | — | 0.20 Max | 0.20 Max |

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

Date : 2007-01-11

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited